

Work Order ID 86131

86131

Page 1

June-21-12 8:24:50 AM

Item ID: D3774-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Seat Bottom, LH/RH

Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/21

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3774	Rev B								
100	HAND FINISHING THERMOFORMING	0.00							
100									
Thermoform	Memo	0.00							
Thermoforming Machine	Set up machine program D3774-1Set up clamping frame as per folio								
110	HAND FINISHING THERMOFORMING	0.00							
110									
Thermoform	Memo	0.00							
Thermoforming Machine	Cut Blanks								

x4

DL
12/06/25

x4

DL
12/06/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

June-21-12 8:24:50 AM

Item ID: D3774-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Seat Bottom, LH/RH

Stop *NS2*

Start Date: 21/06/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

OC:

Date:

SPC (Y/N):

Date:

Stop

NR2

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86131

June-21-12 8:24:50 AM

N900040100

Setup Start *NS1*

Stop *NS2*

4

4

Customer:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

W/O: 46131		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D374-1 PAR #: _____ Fault Category: thermoform NCR: Yes No DQA: ✓ Date: 12/07/17
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed Date: 12/7/18

NCR: 12-1574		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/7/16	#167	During inspection found 4x8 parts with cracks in the corners of the parts. R.C. manufacturing process PROCESS	S 007042 12/07/04	SCRAP + Destroy + NO Replace	Wk. 13/07/04	S 12/07/04	S 12/07/04 007042	S 12/07/04

NOTE: Date & initial all entries

Work Order ID 86131

86131

Page 4

June-21-12 8:24:50 AM

Item ID: D3774-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Seat Bottom, LH/RH

Stop ***NS2***

Start Date: 21/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 05/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: **ST257** 0.00

170

Packaging

Memo

0.00

Packaging

2x **SP**
12-7-5

180

QC21- Final Inspection - Work Order Release 0.00

180

QC

Memo

0.00

Quality Control

OK **12/7/12**

OK
12-07-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-21-12 8:24:54 AM

Page 1

Work Order ID: 86131

86131

Parent Item: D3774-1

D3774-1

Parent Item Name: Seat Bottom, LH/RH

Start Date: 21/06/2012

Required Date: 05/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A New Issue 08.06.04 DL verified by:DD
IPP REV. B Dwg. Update 08.08.19 DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			110	sf	1,739.446	10.667	42.668			

MI FXS 125-F60029-04

GE PLASTICS LEXAN SHEET

**

Location	Loc Qty	Loc Code
MAT018	1503	
121803	1503	
MAT019	236.4464	
119937	236.4464	

42.6758 ft.

Sh
12/06/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	06131
Description: Seat Bottom		Part Number:	D3774-1
Inspection Dwg: D3774	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:	<i>Dr.</i>	Date:	12/06/25
--------------	------------	-------	----------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100	1.33"	✓		TAPE DX-01	
33.9	+/-0.100	33.8"	✓		TAPE DX-01	
17.4	+/-0.100	17.4"	✓		TAPE DX-01	
0.085	Min	0.097"	✓		CAL TH-DT	
0.100	Min	0.109"	✓		CAL TH-DT	
0.100	Min	0.112"	✓		CAL TH-DT	
0.100	Min	0.112"	✓		CAL TH-DT	
0.100	Min	0.108"	✓		CAL TH-DT	

Measured by:	<i>Dr.</i>	Date:	12/06/26
Audited by:	<i>S</i>	Date:	12/07/01
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL <i>Dr.</i>	<i>Dr.</i>

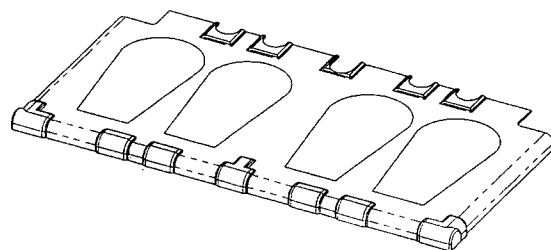
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

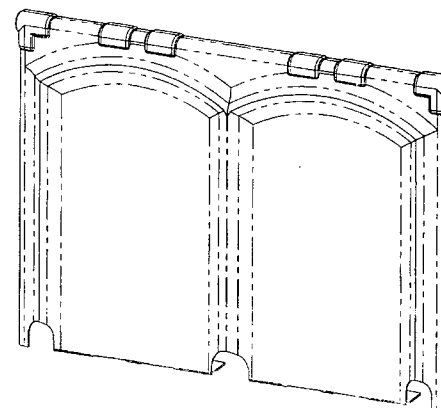
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3774-1 SEAT BOTTOM



D3774-3 SEAT BACK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 26131 MLJ

12/06/21

RELEASED
06-08-11/11

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES		PH	08.07.25
A	NEW ISSUE		HS	08.06.23
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	PH			
CHECKED	PH	DRAWING NO.	REV. B	
MFG. APPR.	PH	D3774	SHEET 1 OF 3	
APPROVED	PH	TITLE	SCALE	
DE APPR.	PH	SEAT	NTS	
DATE	08.07.25		<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

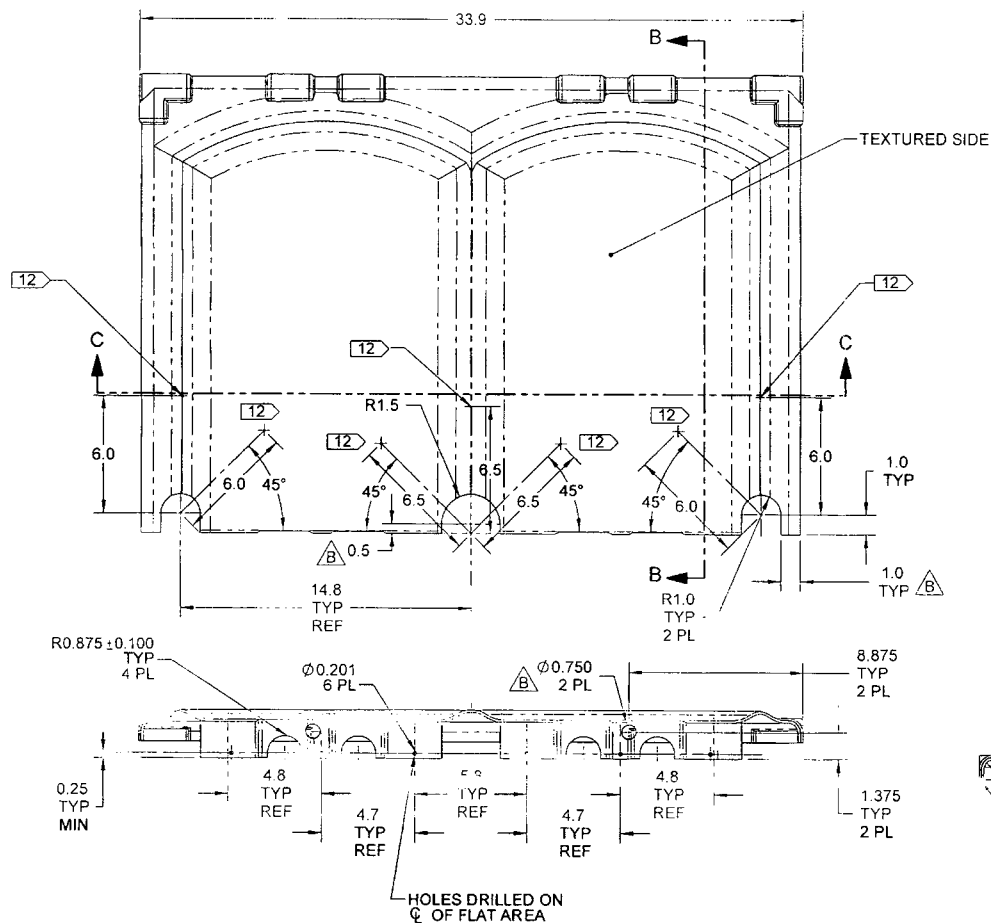
5

4

3

2

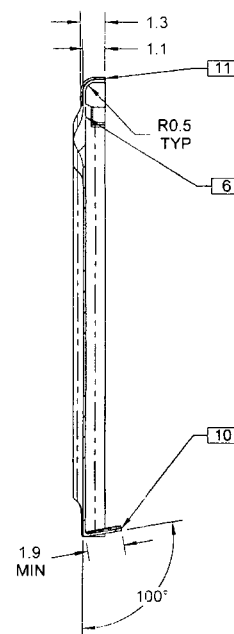
1



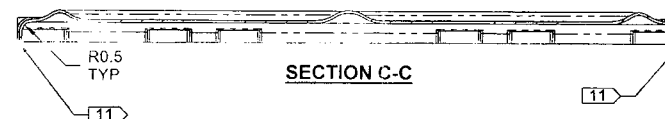
D3774-3 SEAT BACK

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
- 7) WEIGHT: 4.82 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
- 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
- 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100



SECTION B-B



SECTION C-C

RELEASED
08-05-11

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RE		
CHECKED	LS	DRAWING NO. D3774	REV. B
MFG. APPR.	LS	SHEET 3 OF 3	
APPROVED	LS	TITLE SEAT	SCALE NTS
DE APPR.	LS	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.07.25		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries